

Date: Tuesday, 15/08/2006 7:53:21 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HEATER BRACKET
Job Number : 28129	
Estimate Number : 12159	
P.O. Number : N/A	Part Number : D2002003
This Issue : 15/08/2006 S.O. No. : N/A	Drawing Number : D2002-003 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : 10/08/2006 Type : SMALL /MED FAB	Drawing Revision : C
Previous Run :	Material : N/A
Written By :	Due Date : 10/09/2006 Qty: 4 Um: Each
Checked & Approved By :	
Comment : Est. B 99.05.21 Re-format, Made in house DM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S063	2024-T3 .063 sheet
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Comment: Qty.: 0.4083 sf(s)/Unit Total : 1.6334 sf(s)

2024-T3 .063 sheet

Material: 2024-T3, 0.063" Thick

Batch ~~M2024~~ 1905A

SAD 06-08-16

4

2.0	WATER JET	FLOW WATER JET
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Dwg C
 Prog C



Comment: FLOW WATER JET

SAD 06-08-16

4

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 06-08-16

4

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

06-08-20 4

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 Countersink holes as per Dwg D2002-003

IF 06-08-30 4

Deburr

Form as per Dwg D2002-003

SB 06-08-31 4

S.I. QCS Inspect work.

06-08-31 4

PTO →

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Drawing Name: HEATER BRACKET

Job Number: 28129

Part Number: D2002003

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI-005 4.1

SAP 06-08-02

(4)

7.0

QC3

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O.

Powder Coat Black Crinkle (Ref. 4.3.5.3) as per QSI 005 4.3

a.m. 06-09-07

(4)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PV6/9/8 (4)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 198

PV6/9/8 (4)

P10 ->

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Q 06/09/07

Job Completion



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Date: Thursday, 10/08/2006 10:01:37 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HEATER BRACKET
Job Number	: 28129		
Estimate Number	: 12159		
P.O. Number	:	Part Number	: D2002003
This Issue	: 10/08/2006	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D2002-003 REV C
First Issue	: / /	Project Number	: N/A
Previous Run	:	Drawing Revision	: C
Written By	:	Material	:
Checked & Approved By	:	Due Date	: 10/09/2006
Comment	: Est. B 99.05.21 Re-format, Made in house DM	Qty:	4 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	M2024T3S063	2024-T3 .063 sheet
-----	-------------	--------------------



Comment: Qty.: 0.4083 sf(s)/Unit Total : 1.6334 sf(s)
 2024-T3 .063 sheet
 Material: 2024-T3, 0.063" Thick
 Batch _____

Waterjet

2.0	SHEAR	SHEAR
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Comment: SHEAR
 Cut blanks: 9.350" x 5.930"
 Grain Along 5.930"

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per folio D2002-003

D20

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 Countersink holes as per Dwg D2002-003
 Deburr
 Form as per Dwg D2002-003

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
06-08-31	5.0	Need QC 5 After deburr forming. Perm. Change	E	06-09-28		AB 05/28	06-08-31	
06-08-31	7.0	QC Should be QC 3 for Alocine. Perm. Change	E	06-09-28		AB 05/28	06-08-31	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/09/27
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-05-16 SAD	2	Scrap 3 pieces on the waterjet the hole of those pieces were not to big because of the Drawing "Program" for the waterjet	AB 05/28	Scrap and destroy	06-05-16 SAD	06-08-20	AB 05/28	06-08-20

NOTE: Date & initial all entries

Date: Thursday, 10/08/2006 10:01:37 AM
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Process Sheet

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Drawing Name: HEATER BRACKET

Job Number: 28129

Part Number: D2002003

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O: _____

Powder Coat Black Crinkle (Ref. 4.3.5.3) as per QSI 005 4.3

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



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Dart Aerospace Ltd

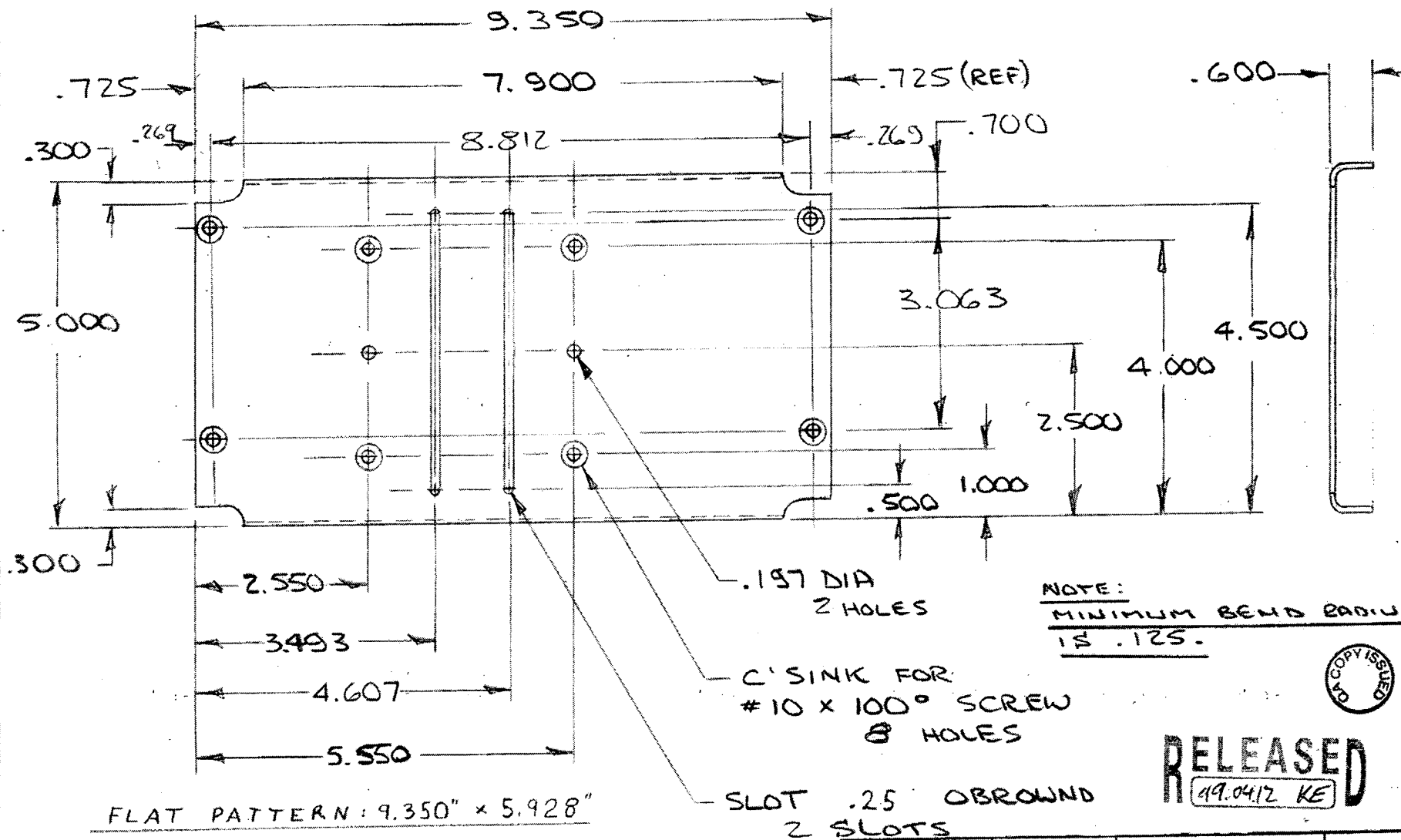
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



C B A		REVISION	RIVET CODE SHALL BE PER NAS 623		D2002-003 BRACKET		2024-T3 X.063		QQ-A-250/5	
KE	JB	JB	DRAWN	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.	BASIC CODE	DIA. DASH NO. H-HEAD RIGID SIDE P-HEAD FEA SIDE	CONTRACT NO.	DART AERO ACCESSORIES INC. VANCOUVER CANADA		
9/12/78	9/12/78	9/12/78	APPROVED	REQUIREMENTS — UNLESS OTHERWISE SPECIFIED	D-DIMPLE D-DIMPLE NO OF SHEETS C-COUNTERSINK	LENGTH DASH NO W-SPOTWELD	DRAWN BRADLEY	DATE 9/19/10	TITLE BRACKET	
DESCRIPTION OF CHANGE			GENERAL	LIMITS	BASIC CODES		DESIGN BRADLEY	DATE 9/19/10	REV. C	
1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS 125 3. REMOVE SHARP EDGES .015 MAX 4. THREADS PER IN. S - 7742 5. HOLES PER AND 10287			1. TOLERANCES — JOK 1 .030 JOK 2 .010 2. ANGLES 1 1/2° 3. PARALLELISM 1 .0025 4. ECCENTRICITY 1 .005 MAX 5. SYMMETRY ABOUT ALL HPG CENTRE LINES .005		8-ME204704D 88-ME204764D		STRESS		CODE YU	
			REPORT ALL DISCREPANCIES — DO NOT SCALE		CHECKED		SCALE 1:2		SHT 1 OF 1	



RELEASED
49.04.12 KE

2002

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